

20-8565



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3290-3

Job Sheet 213325



Part No: D3290-3

Job Qty: 6 pcs

Part Name: Window



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/23/20

Job Tracking No:

Due Date: 10/26/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C IPP A (14.08.18 New issue KJ/RF IPP B IPP C 07.05.29. Thermoform in-house DL IPP D 07.09.28 rev C dwg EC verified by: DD IPP E 07.11.28 Add --Hand finish deburring DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	6 pcs	10/26/20	10/26/20	0.00	0.00	Purchasing - 1	RE OCT 06 2020
							Purchasing - 2	
							Purchasing - 3	
105	Packaging 2-1 - Receive - B4B	6 pcs	10/26/20	10/26/20	0.00	0.00	Packaging 2 - 1 - B4B	RE OCT 06 2020
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartmfg.com
www.dartaerospace.com

Container No: S305032



Part: D3290-3

Job No: 213325

Serial No/Batch: S305032

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/06/20

Plex 10/6/20 8:32 AM dart.lussier.patrick

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
110	QC 6	6 pcs	10/26/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
					QC 6 - 82	
190	Packaging 3-1 - Stock - B4B	6 pcs	10/26/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
200	QC 21 - SA	6 pcs	10/26/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 100 - (Purchasing) ISSUE P/O: POHB047178 SUPPLIER:PLASTECH MANUFACTURE D3290-3 AS PER

Patrick Lussier Plex 10/6/20 8:32 AM dart.lussier.patrick

Descriptions: DWG C OF C IS REQUIRED

105 - (Receive & Inspect for Damage & Mat'l Certs)

110 - (QC6- All purchased or subcontracted products) *Windows need to be protected at all time*****

190 - (Identify as per dwg & Stock Location:_____)

200 - (QC21- Final Inspection - Work Order Release)

PO Details

Canus Plastics Inc (ptf001-vc)



PO No: POHB047178

Line No: 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3290-3P	Window	6 Ea (1 ea)	100-Purchasing	\$ 305030
MACRLICS.125	1/8" Polycast li Sheet	39.9960 sf (6.666 ea)	100-Purchasing	\$ 51992

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D3290-3P	6	0	0
	MACRLICS.125	40	945	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window	26.580Inches $\pm$ 0.030	26.610 26.550		
2	Window	16.080Inches $\pm$ 0.030	16.110 16.050		
3	Window	13.790Inches $\pm$ 0.030	13.820 13.760		
4	Window	12.400Inches $\pm$ 0.030	12.430 12.370		
5	Window	8.810Inches $\pm$ 0.030	8.840 8.780		

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB047178



Supplier: PTF001-VC
Canus Plastics Inc
2684 Fenton Rd
Gloucester
ON
K1T 3V2 Canada
Phone: 1-800-267-9699

PO No: POHB047178
PO Date: 9/23/20
Due Date: 10/5/20
Purchase Order
Revision:
Revision Date:
Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	213325	D3290-3P	D3290 C			Window : Various STC's As Per Dwg D3290 Rev. C	Firmed - X6		10/5/20	6 Ea	0 Ea	6 Ea	\$207.50/Ea	\$1,245.00

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OCT 06 2020

[Handwritten signature]

Line Item Note MATERIAL : MACRLICS.125
BATCH # MATERIAL : S151992
QTY AT CANUS : 950 SQ/F

Grand Total: \$1,245.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Please ensure to send the related invoice to hby_ap@dartaero.com.

Plex 10/6/20 8:47 AM dart.charest.martin



128 WALGREEN ROAD, OTTAWA, ON K0A 1L0
PHONE-613-831-4640

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: OCTOBER 5, 2020

YOUR PURCHASE ORDER: PO HB047178 ✓

OUR INVOICE NO: 220447

LINE ITEM # 1

QUANTITY: 6 ✓

DESCRIPTION: REPLACEMENT EXTERIOR WINDOW FOR DWG D3290-3P REV C. ✓

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:

DART QSI 018

PLASTECH PROCESS PR-01-01-D3290 REV 1.0 USING DWG D3290 REV C.

Note: USED 1.25 SHEET - 40 SF OF PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391
TYPE 1 GRADE C, 0.125 THICK (REF DART SPEC. M-ACRYLIC-S.125). BATCH# S151992.

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF
THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT
SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS
AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

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AUTHORIZED REPRESENTATIVE SIGNATURE

MARK PERRY, M.ENG.
PRESIDENT

CANUS PLASTICS INC.

2684 FENTON RD
OTTAWA ON K1T 3T7
Ph. (613) 232-2657 Fax (613) 232-6214
info@canusplastics.com
www.canusplastics.com

Packing Slip

0000222624

Date October 6, 2020
Customer P23336

Bill To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

Ship To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

Ph. (613) 632-3336

Ph. (613) 632-3336

PO Number	F.O.B.	Salesperson	Order Date	Order Number
POHB047178	Our Dock	Mark Perry	October 5, 2020	0000222624
Ship Via		Payment Terms	Reference	
Pick up				
Ordered by		P LUSSIER		
Part Number	Description	Ordered	Shipped	B/O
MFG	PART # D3290-3P; DRAWING D3290 REV C; WINDOWS AS PER DRAWING D3290 REV C	6	6	
Date		Signature		
Total		6		

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RECEIVED
OCT 01 2020
DART AEROSPACE LTD.

Entered: _____ Date: _____

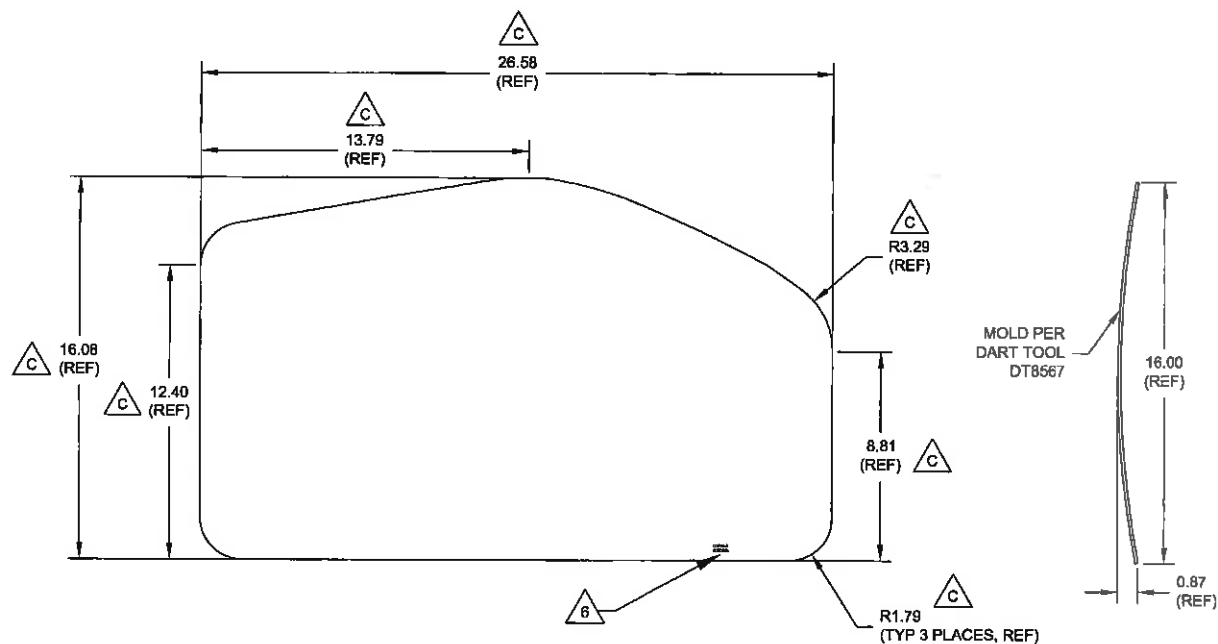


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>213325</u> Part No. <u>D3290-3</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐		
Date : <u>OCT 06 2020</u>	Sequence #: <u>QC 6</u>	QTY Affected : <u>2 OF 6</u>		MRB (QSI042)
Description Work Order Deviation		Disposition		
DURING INSPECTION IT WAS FOUND THAT THE DIMENSIONS 1 (26.580+/-0.030) AND 2 (16.080 +/-0.030) ARE BELOW TOLERANCE: #1 26.520 (-0.030 MIN) AND 16.000 (-0.050 MIN) #2 26.460 (-0.090 MIN) AND 16.020 (-0.030 MIN)		Completed By <u>DAS</u> <u>OCT 06 2020</u> 82 <u>9-89</u>		
		Lead hand / Supervisor		
		QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				



D3290-3 WINDOW

- D3290-3 NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) REMOVE SHARP EDGES
 - 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
 - 7) WEIGHT: 1.87 +/- 0.42 LBS
 - 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

**DEO ATTACHED
RELEASED**

DESIGN	75	DART AEROSPACE LTD	
DRAWN	75	HAWKESBURY, ONTARIO, CANADA	
CHECKED	75	DRAWING NO.	REV. C
MFG. APPR.	75	D3290	SHEET 2 OF 2
APPROVED	75	TITLE	SCALE
DE APPR.	75	REPLACEMENT WINDOW ASSEMBLY 1:5	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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Entered: JR Date: OCT 16 2020



NCR No. 20-8565 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>213325</u> Part No. <u>D3290-3</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐		
Date : <u>OCT 06 2020</u>	Sequence #: <u>QC 6</u>	QTY Affected : <u>2 OF 6</u>		MRB (QSI042) <u>DR 5</u> <u>9-8 S/A 20/10/16</u>
Description Work Order Deviation DURING INSPECTION IT WAS FOUND THAT THE DIMENSIONS 1 (26.580+/-0.030) AND 2 (16.080 +/-0.030) ARE BELOW TOLERANCE: <u>Ref</u> #1 26.520 (-.030 MIN) AND 16.000 (-.050 MIN) #2 26.460 (-.090 MIN) AND 16.020 (-.030 MIN)		Disposition <u>Scrap + destroy</u>		Completed By <u>DAS</u> <u>OCT 06 2020</u> 82 9-89 Lead hand / Supervisor <u>PD 20-10-16</u> QC / QA Coordinator <u>PD 20-10-16.</u>
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				